

Date: Friday, 9/21/2007 1:05:07 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : LEG
Job Number : 34802	
Estimate Number : 12511	
P.O. Number : <i>N/A</i>	Part Number : D35231
This Issue : 9/21/2007	Drawing Number : D3523 UNDER REVIEW
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>N/A</i>	Drawing Revision : <i>N/A</i>
Previous Run : 33294	Material : <i>N/A</i>
Written By : _____	Due Date : 10/12/2007
Checked & Approved By : _____	Qty: <i>20</i> Um: Each
Comment : Est Rev:A New Issue 06-08-21 EC	
Est Rev:B Added Helicoil 07-07-19 JLM	Verified by: EC

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6R1000	ROUND BAR 1.00"
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Comment: Qty.: 0.1218 f(s)/Unit Total : 0.6090 f(s)
 6061-T6 round bar 1.00"
 (M6061T6 round bar 1.00")
 Batch: *M 104554*

DFP 07/09/29

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
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Comment: HARDINGE CNC LATHE SMALL

Machine as per folio FA697 & dwg D3523

DFP 07/09/29

(20)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

DFP 07/09/29

(20)

4.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE
 Drill For Helicoil & Set-Screw

DFP 07/09/20

(20)

5.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

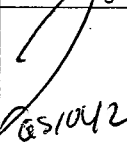
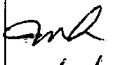
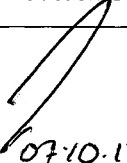
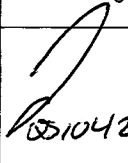
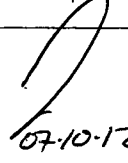
DFP 07/09/30

(20)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/10/04	11	6 heli oil broke	 05/10/12	Scrap and destroy	 07/10/05	 07-10-12	 05/10/12	 07-10-12

NOTE: Date & initial all entries

Date: Friday, 9/21/2007 1:05:07 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LEG

Job Number: 34802

Part Number: D35231

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

ml 07/09/20

20

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Chemical Conversion Coat as per QSI 005 4.1

BR

07-10-01

20

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

-Mask threaded holes & Ball as per Dwg D3523

-Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

E

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

MA 07/10/04

20

10.0

MS21209F120

HELI COIL



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

HELI COIL

Batch: M104996

ml 07/10/04

20

11.0

MILLING CONV.

CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE

Install Helicoil as per Dwg D3523

ml 07/10/04

20

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

counter
07/10/11 (20)

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 55107

07/10/11 (20)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 9/21/2007 1:05:08 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LEG

Job Number: 34802

Part Number: D35231

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

QC21

FINAL INSPECTION/W/O RELEASE



(2)

Comment: FINAL INSPECTION/W/O RELEASE

12/21/10

Job Completion



U 8/10/12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

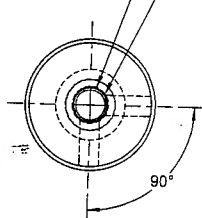
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

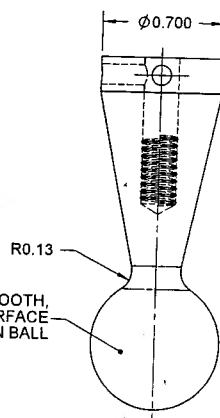
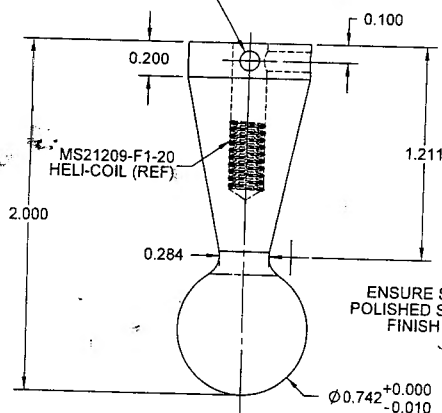
NOTE: Date & initial all entries

DRILL #7 ($\phi 0.201$) x 0.83 DEEP $\triangle B$
TAP HOLE FOR #10-32 HELI-COIL INSERT (RED)

INSTALL MS21209-F1-20 HELI-COIL
TO THE BOTTOM OF THE HOLE



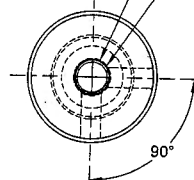
DRILL #33 ($\phi 0.113$)
TAP #6-40 UNF
(2 PLACES)



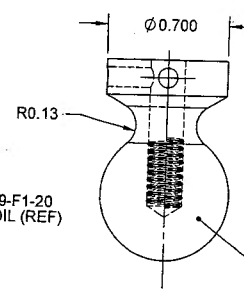
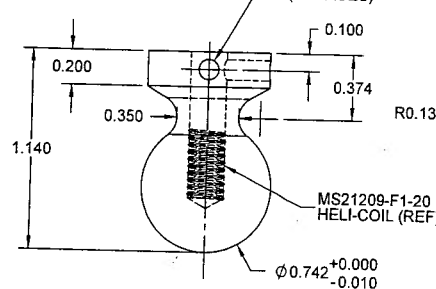
D3523-1 LEG

DRILL #7 ($\phi 0.201$) x 0.83 DEEP $\triangle B$
TAP HOLE FOR #10-32 HELI-COIL INSERT (RED)

INSTALL MS21209-F1-20 HELI-COIL
TO THE BOTTOM OF THE HOLE



DRILL #33 ($\phi 0.113$)
TAP #6-40 UNF
(2 PLACES)



D3523-3 LEG

RELEASED
07.08.03



NOTES:

- 1) MATERIAL: ALUMINUM 6061-T6/T651/T6511/T62 ROUND BAR PER QQ-A-225/8 OR AMS 4115/4116/4117/4128 OR QQ-A-200/8 OR AMS 4160 (REF DART SPEC M6061T6R)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D3523-1: 0.05 lbs
D3523-3: 0.03 lbs

NO. _____
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

B	ZONE D7, D3: HOLE DEPTH REVISED FROM 0.69 TO 0.83 ZONE A8: UPDATE NOTES; ADD WEIGHT UPDATE DRAWING FORMAT	CB	07.07.25
A	NEW ISSUE	CB	07.06.18
REV.	DESCRIPTION	BY	DATE
DESIGN	CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	CB		
CHECKED	CB	DRAWING NO.	REV. B
MFG. APPR.	CB	D3523	SHEET 1 OF 1
APPROVED	CB	TITLE	SCALE
DE APPR.	CB	LEG	3.2
DATE	07.07.25	COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

